MicroSol® 606 bd is a blue dyed, microemulsion semisynthetic coolant made specifically for machining aluminum, steel, and alloy steel. It provides excellent cooling and mechanical lubricity, along with the machine friendly characteristics you expect from a premium TRIM® coolant.

**MicroSol**

Choose MicroSol 606 bd:
- Versatile product that does an outstanding job in milling, drilling, and tapping cast or wrought aluminum, vertical or horizontal machining center work on alloy steel, surface and centerless grinding, and in general-purpose, job shop operations
- Contains very effective, extreme-pressure additives to control built-up edge
- Compatible with all ferrous and nonferrous materials
- Very fine emulsion gets to the point of cut
- Rejett's tramp oil to extend sump life and increase recycling options
- Leaves a soft fluid film to prevent sticky ways, chucks, tool holders, and fixtures
- Coolant residue is easily removed with water, working solution, or Master STAGES™ aqueous cleaners
- Easily recycled or disposed of with conventional techniques and equipment
- Very stable with long sump life and minimal carryoff
- Runs for long periods without the need for costly additives

**MicroSol 606 bd especially for:**

**Applications** — centerless grinding, general purpose, horizontal machining, job shop operations, machining, surface grinding, tapping, and vertical machining

**Metals** — aluminum, cast aluminum, ferrous metals, nonferrous metals, steel alloys, and steels

**Industries** — aerospace and job shop

MicroSol 606 bd is free of — NPEs and triazine
MicroSol® 606 bd

Long-life Microemulsion - Blue Dye

Application Guidelines

- Can run at lower concentrations for higher speed operations where heat removal is the key issue, or run at higher concentrations on soft, gummy materials for lower speed operations where friction reduction and control of built-up edge are critical.
- Keeping MicroSol 606 bd at 7% or higher concentration provides the best sump life.
- For additional product application information, including performance optimization, please contact your Master Fluid Solutions’ Authorized Distributor at https://www.2trim.us/distributors.php, your District Sales Manager, or call our Tech Line at 1-800-537-3365.

Physical Properties Typical Data

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color (Concentrate)</td>
<td>Dark blue</td>
</tr>
<tr>
<td>Color (Working Solution)</td>
<td>Blue</td>
</tr>
<tr>
<td>Odor (Concentrate)</td>
<td>Mild</td>
</tr>
<tr>
<td>Form (Concentrate)</td>
<td>Liquid</td>
</tr>
<tr>
<td>Flash Point (Concentrate) (ASTM D93-08)</td>
<td>&gt; 210°F</td>
</tr>
<tr>
<td>pH (Typical Operating as Range)</td>
<td>8.8 - 9.2</td>
</tr>
<tr>
<td>Coolant Refractometer Factor</td>
<td>1.0</td>
</tr>
<tr>
<td>Titration Factor (CGF-1 Titration Kit)</td>
<td>2.00</td>
</tr>
<tr>
<td>Digital Titration Factor</td>
<td>0.0582</td>
</tr>
<tr>
<td>V.O.C. Content (ASTM E1868-10)</td>
<td>95 g/l</td>
</tr>
</tbody>
</table>

Recommended Metalworking Concentrations

- Light duty: 3.0% - 6.0%
- Moderate duty: 6.0% - 8.0%
- Heavy duty: 8.0% - 9.0%
- Design Concentration Range: 3.0% - 9.0%

Concentration by % Brix

% Concentration = Refractive Reading x Refractive Factor

Coolant Refractometer Factor % Brix = 1.0

Concentration by Titration

% Concentration = No. of Drops x Titration Factor

Titration Factor = 2.00

Health and Safety

See the most recent SDS at https://2trim.us/s/?i=1014-0-en-US-US
MicroSol® 606 bd
Long-life Microemulsion - Blue Dye

Mixing Instructions

- Recommended usage concentration in water: 3.0% - 9.0%.
- To help ensure the best possible working solution, add the required amount of concentrate to the required amount of water (never the reverse) and stir until uniformly mixed.
- Use premixed coolant as makeup to improve coolant performance and reduce coolant purchases. The makeup you select should balance the water evaporation rate with the coolant carryout rate. Use our Coolant Makeup Calculator to find the best ratio for your machine: apps.masterfluidsolutions.com/makeup/.
- Use mineral-free water to improve sump life and corrosion inhibition while reducing carryoff and concentrate usage.

Additional Information

- Use Master STAGES™ Whamex™ for a quick and thorough precleaning of your machine tool and coolant system.
- Consult Master Fluid Solutions before using on any metals or applications not specifically recommended.
- This product should not be mixed with other metalworking fluids or metalworking fluid additives, except as recommended by Master Fluid Solutions, as this may reduce overall performance, result in adverse health effects, or damage the machine tool and parts. If contamination occurs, please contact Master Fluid Solutions for recommended action.
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